

TRONXY

Moore X2540

Clay 3D printer User Manual

陶泥3D打印机使用说明书





When unpacking, please check the packing list to ensure that no parts are lost or damaged. If any, please contact our after-sales personnel immediately and we will reissue them for you in the shortest time.

开箱时, 请对照装箱清单, 确保无零件的丢失及损坏, 如有发生, 请立即联系我们的售后人员, 我们会在最短时间内为您补发。



Warning: The machine must use single-phase AC 110V/220V and the machine must be grounded.

警告: 本机必须使用单相110V/220V交流电, 机器必须进行接地线。



Note: High voltage part is inside the machine, please under guidance of professionals while opening machine for troubleshooting.

注意: 机器内部有高压电部分, 当需要打开机器进行检修时请在专业人士的指导下进行。



Do not touch the heating element during heating process

机器在加热过程中请勿触摸加热部件



The machine contains high-speed moving parts. Children are not allowed to use the printer alone.

It is not recommended to use this 3D printer when unattended.

该机器包含高速运动部件, 儿童不得单独使用打印机;
无人看管情况下, 不建议运行 3D 打印机。



Please use the machine in a ventilated, dry, clean and flat environment.

请在通风、干燥、清洁、平坦的环境中使用机器。



The recommended room temperature for 3D printers is 8°C-40°C, and the humidity is 20% - 80%. If used outside this temperature and humidity range, it may lead to a bad printing effect.

3D 打印机的使用环境温度建议为 8°C-40°C, 湿度为 20%-80%, 在此范围之外使用, 可能带来不良的打印效果。



In an emergency, you can turn off the power directly.

在紧急情况下, 可直接关闭电源。



If the user's unauthorized modification or disassembly causes damage to the core components of the machine, the situation is not covered by the warranty.

如果用户擅自改装或者拆卸导致机器的核心部件损坏, 则该情况不在保修范围内。



Use and maintain the machine following the manual.

根据说明手册对机器定期进行使用和保养。



Video, software, and other related information are stored on the USB flash drive. Please check.

视频, 软件等相关信息存储在U盘中, 请查看。

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Parameter 设备参数

Print parameters

打印参数

Printing principle :	LDM (Liquid Deposition Molding)
打印原理	LDM (液体沉积成型)

Print volume :	255*255*400(mm)
打印体积	

Printing accuracy :	0.3-3.0mm
打印精度	

Positioning accuracy :	X/Y: 0.00625mm, Z:0.00125mm
定位精度	

Number of printhead :	1
喷头数量	

Nozzle diameter :	1.0-3.0 mm (optional)
喷嘴直径	1.0-3.0 mm (可选)

Print speed :	10~200mm/s (20mm/s is recommended)
打印速度	10~150mm/s (建议20mm/s)

Moving speed :	300mm/s
移动速度	

Consumables :	Various clays such as pottery clay, porcelain clay, purple sand clay, etc
耗材	陶泥、瓷泥、紫砂泥等各种黏土

Temperature parameter

温度参数

Ambient temperature :	8°C - 40°C
环境温度	

Software parameters

软件参数

Slicing software :	Cura
切片软件	

Input format :	.STL .OBJ
输入格式	

Output format :	Gcode
输出格式	

Connection method :	USB
连接方式	USB

Power parameters

电源参数

Power input :	115-230V 50/60HZ
电源输入	

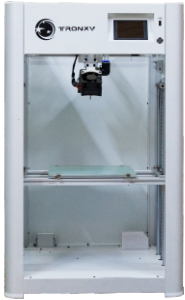
Power output :	100W
电源输出	

Physical parameters

物理参数

Machine size :	497.5*497.5*805(mm)
机器尺寸	

Packing list 包装清单

1  Machine body 机器主体	3  Fiberglass board plate 玻纤板	4  Barrel 料筒	5  Tube*2 料管*2
2  Pushing device 推料装置	6  Nozzles * 3 (1.6/2.0/3.0mm) 喷嘴*3 (1.6/2.0/3.0mm)	7  Clay*2 陶泥*2	8  Power line 电源线
	9  TF card, card reader TF卡、读卡器	10  L-shaped wrench L型扳手	11  Screwdriver 螺丝刀
	12  Wrench 扳手	13  Cling film 保鲜膜	14  Teflon tape 生料带

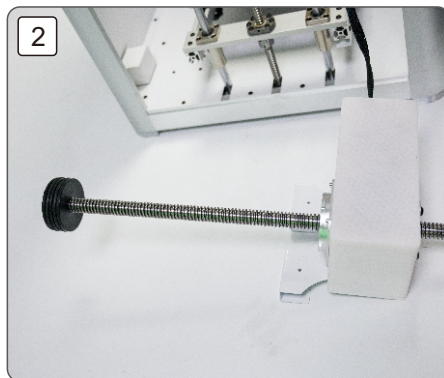
Machine installation and use

机器安装与使用

Machine installation and use 机器安装与使用



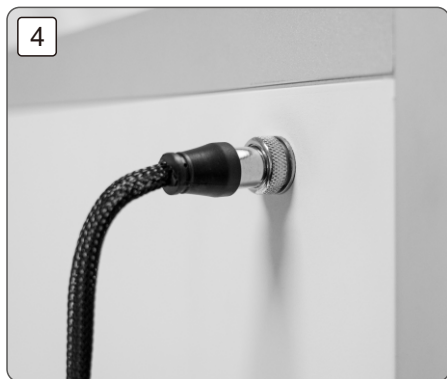
Remove the Barrel
取下料筒



As shown in the figure
如图所示



Insert power and turn on the switch
插入电源, 打开开关



Insert the connection line of the pushing device
插入推料装置连接线



Turn on the switch
打开开关



Click on "Tools"
点击“工具”

Machine installation and use 机器安装与使用



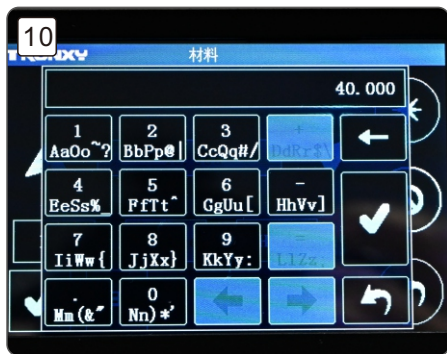
Click on "Materials"
点击“材料”



Click on " " and switch to " "
点击“ ”, 切换到“ ”



Click to set the push ratio
点击设置推料比

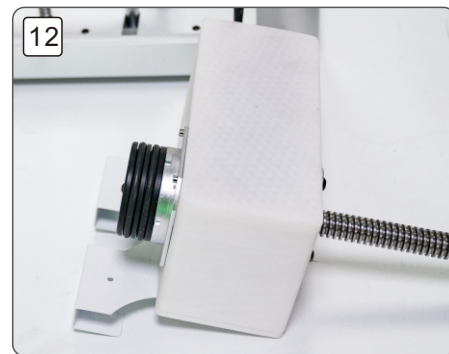


Set to 40
设置成40



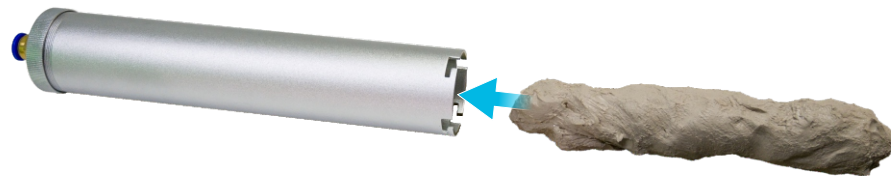
1. Click "High" to switch to high-speed mode
2. Click on the " " twice to exit the material

1、点击“High”切换成高速模式
2、点击两次“ ”, 退出材料



The piston retreats to the bottom,
click on the " " to stop
活塞退到底部, 点击“ ”停止

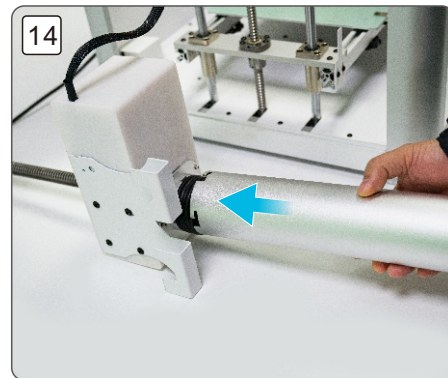
13



Put the clay into the material barrel and compact it

将陶泥放入料筒中，并压实

14



Install the material barrel back into the pushing device

将料筒安装回推料装置

15



Hang the pushing device onto the machine

将推料装置挂到机器上

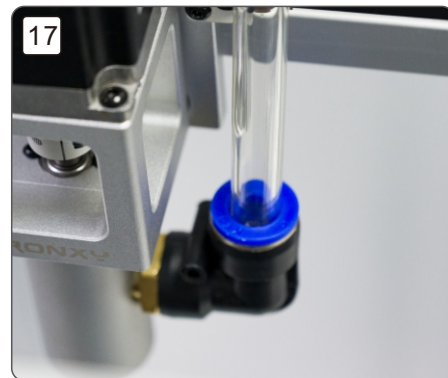
16



Connect the material tube to the material barrel

将料管连接料筒

17



Connect the extrusion head on the other side of the material tube, complete installation

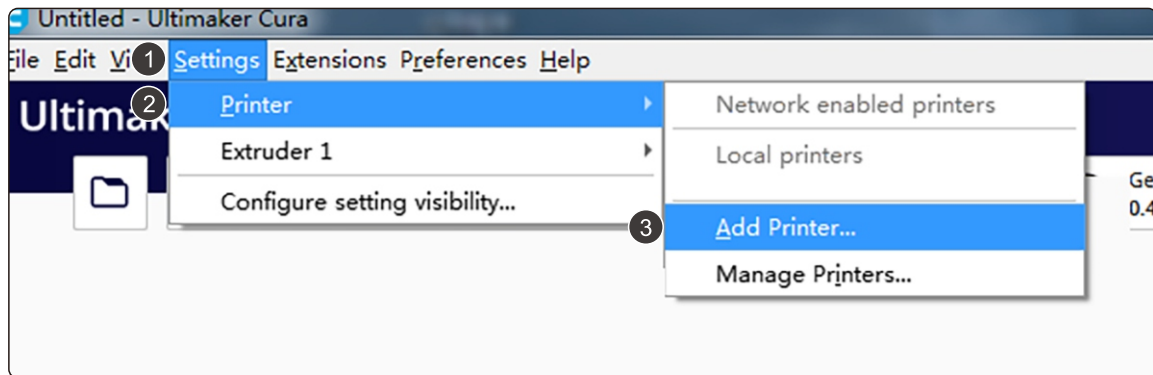
料管另一边连接挤出头，完成安装

Slice Software Installation Steps

切片软件安装设置

Slice Software Installation Steps 切片软件安装设置

1. Install "Ultimaker_Cura-amd64" on the computer, double-click to install the software, and follow the prompts to complete the installation steps;
在电脑上安装“Ultimaker_Cura-amd64”，双击安装软件，按照提示完成安装步骤；
2. Add a printer;
添加打印机；

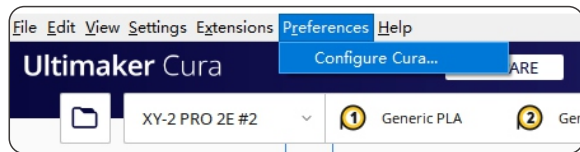


① Settings → ② Printer → ③ Add Printer...
设置 → 打印机 → 新增打印机

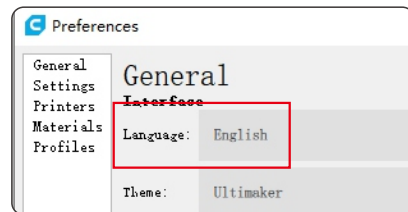


How to change the language of slicing software

切片软件如何更换语言

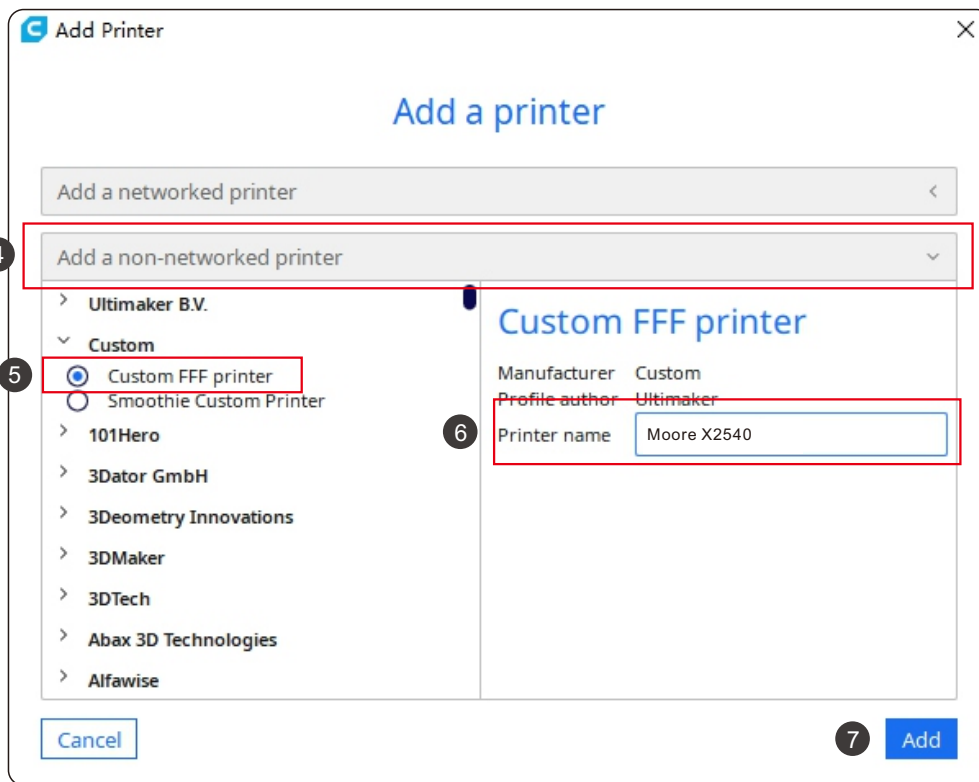


Preferences → Configure Cura...
偏好设置 → 配置Cura



After selecting the desired language, restart the software
选择好需要的语言后，后重启软件即可

Slice Software Installation Steps 切片软件安装设置



- ④ Add a non-networked printer → ⑤ Custom FFFprinter → ⑥ Enter "Moore X2540"
点击“添加未联网打印机” 选择“Custom FFFprinter” 输入“Moore X2540”
- ⑦ Add
点击“添加”

Slicing software settings 切片软件 的设置

Add Printer

Machine Settings

Moore X2540

Printer

Printer Settings

X (Width)

255.0

mm

Y (Depth)

255.0

mm

Z (Height)

400.0

mm

Build plate shape

Rectangular

Origin at center☐

Heated bed☐

Heated build volume☐

G-code flavor

Marlin

Start G-code

G28 ;Home

Extruder 1

Printhead Settings

X min

-20

mm

Y min

-10

mm

X max

10

mm

Y max

10

mm

Gantry Height

260.0

mm

Number of Extruders

1

Apply Extruder offsets to GCode☒

End G-code

M104 S0

Next

Add Printer

Machine Settings

Moore X2540

Printer

Nozzle Settings

Nozzle size

3.0

mm

Compatible material diameter

3.0

mm

Nozzle offset X

0.0

mm

Nozzle offset Y

0.0

mm

Cooling Fan Number

0

Extruder Start G-code

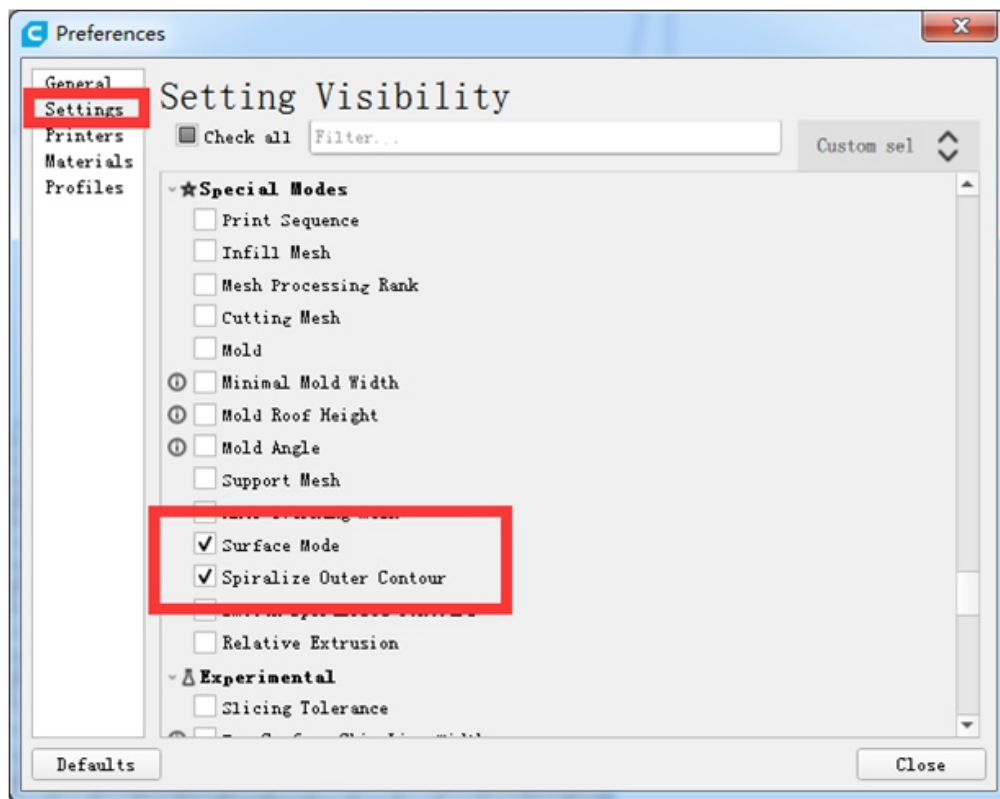
Extruder End G-code

Extruder 1

Next

Set the value as shown in the figure
如图所示设置数值

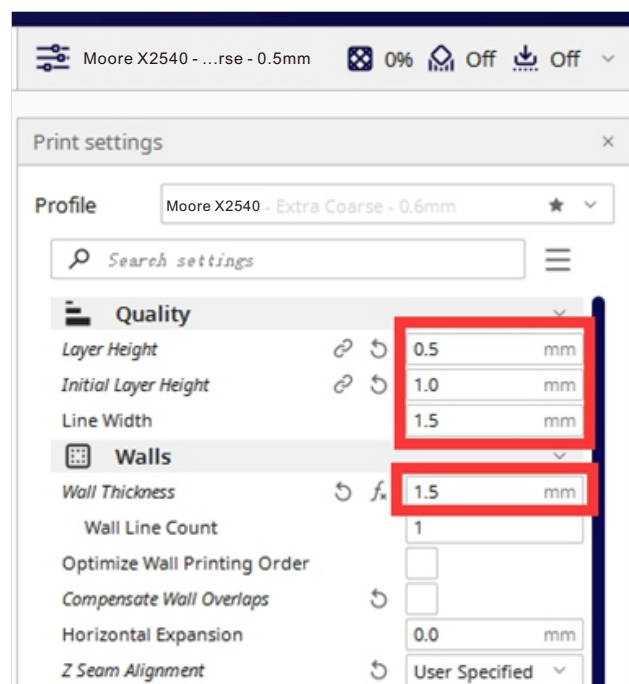
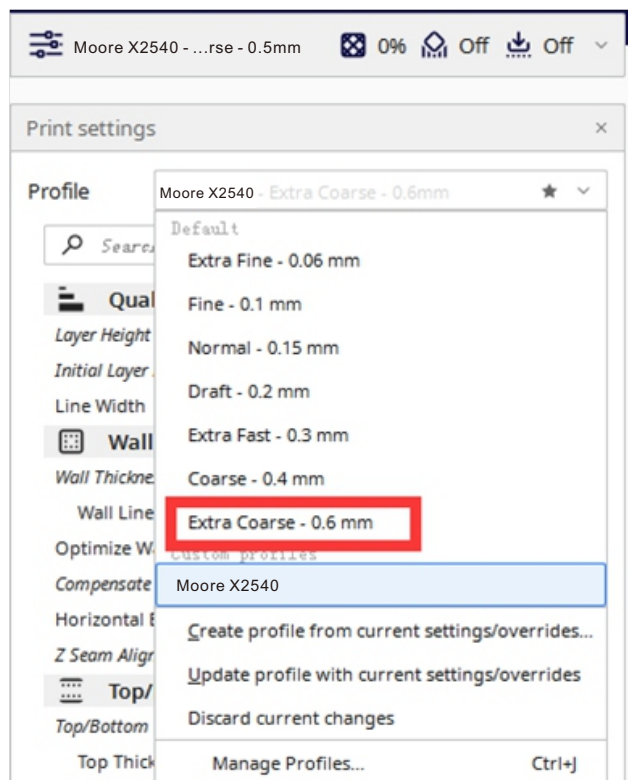
10



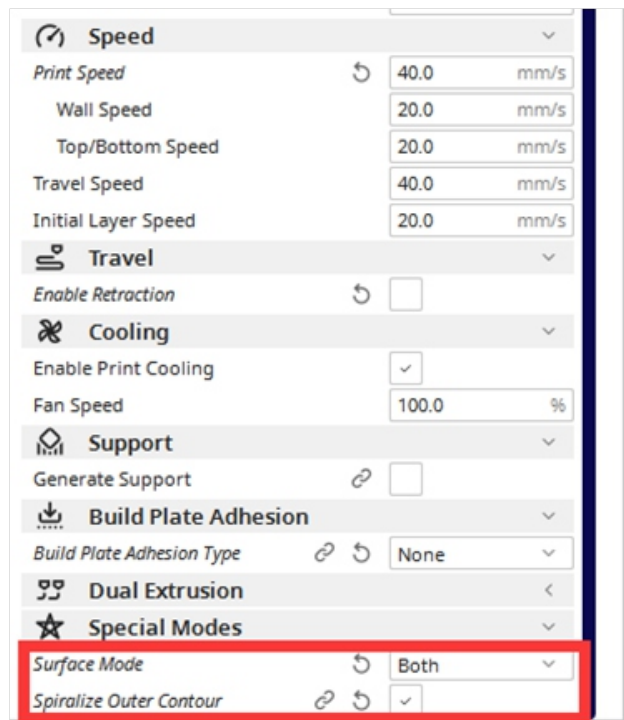
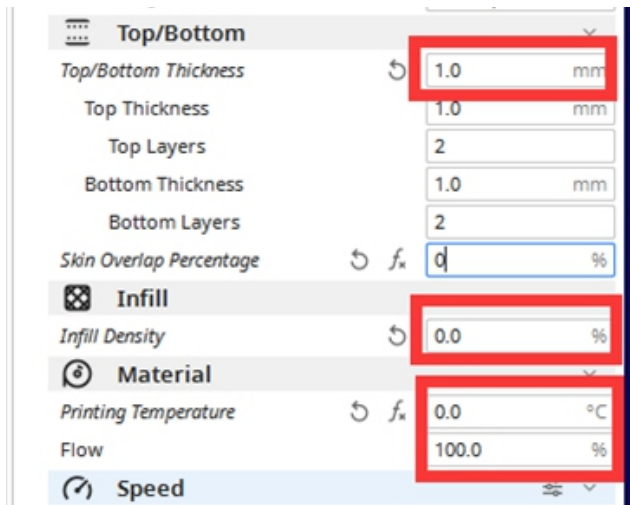
Select the option in the red circle

勾选红圈中的选项

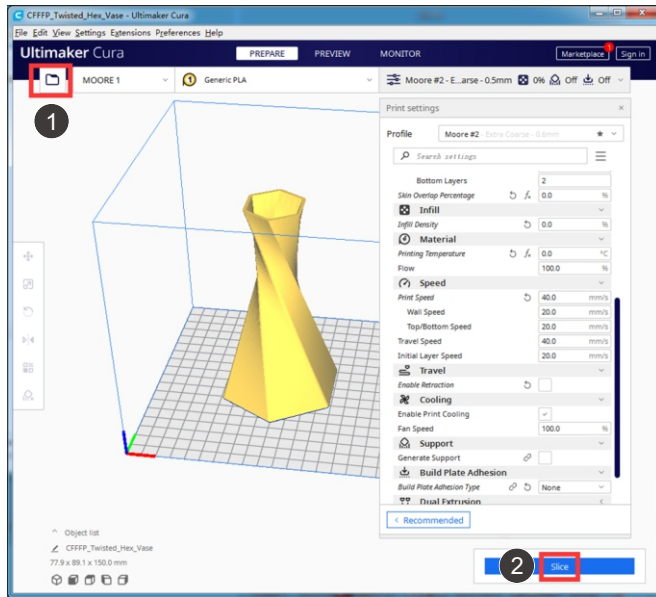
2. parameter settings 参数设置



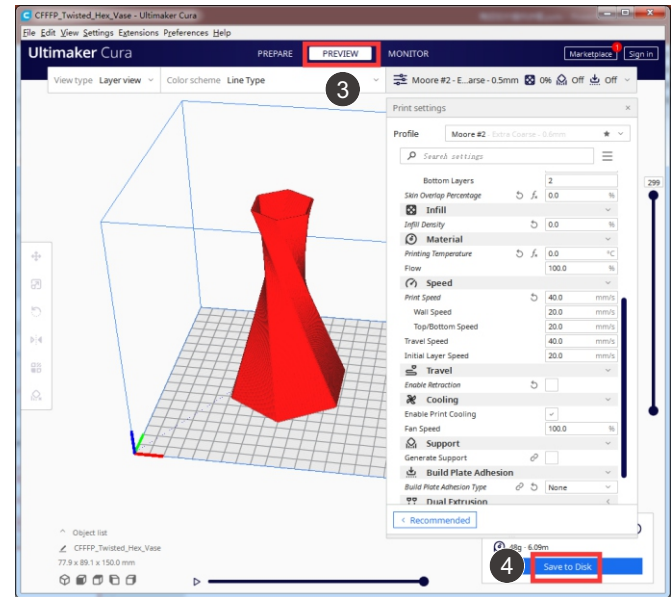
Slicing software settings 切片软件的设置



Slicing software settings 切片软件 的设置



① Open a file → ② Slice
打开一个文件 切片



③ Preview → ④ Save to Disk
预览 保存到磁盘

Due to the differences between different machine models, the physical objects and the final images can differ.

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